



(5)
Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4309-1
Job Sheet 177417



Part No: D4309-1

Job Qty: 30 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/10/18

Job Tracking No:

Due Date: 5/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 11-01-11 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		5/22/18	0.00	0.00	Start Up Machining-2		VHS 18/5/16
100	Hardinge	30 pcs		5/22/18	0.00	1.97	Hardinge		VHS 18/5/16
120	QC	30 pcs		5/22/18	0.00	0.00	QC8		MAK 18/05/15
123	HandFinish	30 pcs		5/22/18	0.00	0.51	HandFinish1		SA 18-05-16
126	QC	30 pcs		5/22/18	0.00	0.00	QC7-3		001 MAY 18 2018
130	Packaging	30 pcs		5/22/18	0.00	0.00	Packaging3-2	5x085	DAS 6 MAY 22 2018
140	QC21-SA	30 Ea		5/22/18	0.00	0.00	QC21		9-89 DAS 21 0-80 MAY 22 2018

Part Op
Descriptions: 100 - 1-TURN AS PER FOLIO FB034 & DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	2.4999 ft (.08333 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	2	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.870Inches ± 0.010	0.880 0.860		
2	Bushing	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
3	Bushing	0.450Inches + 0.000 - 0.004	0.450 0.446	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

DEFART
 AEROSPACE
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 CANADA
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 www.defartospace.com

Container No: S071859
 Part: D4309-1
 Job No: 177417
 Serial No/Batch: S071859
 Revision: _____
 Inspector: _____
 Date: 06/16/18

QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								